

Work Order ID 64987

Wednesday, January 05, 2011 1:01:50 PM



Page 1

Item ID:	D3913-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Base Assembly, 350					
Start Date:	1/5/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	1/14/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>PL</u>	Date:	<u>11-01-15</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3913	A

100	Weld per dwg A/R S.S. rod Batch: <u>1114649</u>	0.00
	Large Fab	
Large Fab	Memo	0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A
 inspect before welding mesh
 2- tack weld mesh on basket as per dwg D3913 and trim mesh to fit if necessary
 and trim to clear fasteners holes on the ends
 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket

11/01/19 (1x)

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
QC	Memo	0.00
Quality Control		

11-01-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Accept



Setup Start



Revision ID:

Stop



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Start Date: 1/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BR 11-01-24.

W/O:		WORK ORDER CHANGES					
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	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
	<i>M115951.</i>					<i>1</i>			
	Powdercoat	0.00							
	Powder Coating								
	Memo								
	1- Plug holes and mask only interior of hinge (3) prior to powder coat								
	1ST COAT:								
	START TIME: <i>8:50</i>								
	OVEN TEMPERATURE: <i>400°</i>								
	FINISH TIME: <i>9:20</i>								
	*****2nd coat if necessary*****								
	2ND COAT:								
	START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								
140 	QC3- Inspect Part Finish	0.00							
	QC								
	Quality Control								
	Memo								

EB 11/01/24

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

Pick Kit

GB 1/01/24 ②

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sublocky

④

170

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

w/o 64985

GB 1/01/24 ①

W/O:		WORK ORDER CHANGES					
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Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

62 11/01/25
MF

11-01-24

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Picklist Print

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Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 1/5/2011





Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2581  Mounting Bracket		Manufactured	No			100	Each	43.0000	2	2		11/01/18	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				43					
					64112			20					
					64425			23					
✓ D3913-1  Rib		Manufactured	No			100	Each	2.0000	1	1		11/01/18	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				2					
					60731			2					
✓ D3913-15  Wide Handle Plate		Manufactured	No			100	Each	3.0000	1	1		11/01/18	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				3					
					63627			3					
✓ D3913-3  Rib		Manufactured	No			100	Each	3.0000	1	1		11/01/18	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				3					
					64107			3					

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Page 2

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Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

* D3913-7
Rib

Manufactured No

100 Each

6.0000

2

2



11/01/18

Location

Loc Qty

Loc Code

WA

6

60263

4

63623

2

(2x)

✓ D3913-9
Hinge Rib

Manufactured No

100 Each

3.0000

1

1



11/01/18

Location

Loc Qty

Loc Code

WA

3

63770

3

(1x)

✓ D3916-041
Rib Assembly

Manufactured No

100 Each

4.0000

2

2



11/01/18

Location

Loc Qty

Loc Code

WA

4

64170

4

(2x)

✓ D3916-5
Light Rib

Manufactured No

100 Each

4.0000

3

3



B64167 (3x) 11/01/18

Location

Loc Qty

Loc Code

WA

4

57023

2

63856

2

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Shop Packet Print

Page 2

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Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00



Required Qty: 1.00

✓ D4021-1 Manufactured No 100 Each 12.0000 3 3

 Handle Plate
 11/01/18



Location Loc Qty Loc Code

ST109 5
 57086 5
 WA 7
 64136 7

✓ D4034-041 Manufactured No 100 Each 1.0000 1 1

 Aft Upper Rib Assembly
 3x
B64904 11/01/18



Location Loc Qty Loc Code

WA 1
 63621 1

✓ D4034-043 Manufactured No 100 Each 2.0000 1 1

 Fwd Upper Rib Assembly
 B63620 11/01/18

Location Loc Qty Loc Code

WA 2
 63620 2

AN3-10A Purchased No 150 Each 133.0000 6 6

 Bolt
 11/01/24

Location Loc Qty Loc Code

ST351 133
 115877 1
 116075 32
 116400 100

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Page 4

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Page 5

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD8 NAS1149DN832 Purchased No
J
Washer 150 Each 10.0000 2 2
6DM46513 (20)

Location Loc Qty Loc Code
ST347 10

105059 10

D2931 Manufactured No
Bumper 150 Each 744.0000 2 2

Location Loc Qty Loc Code
ST504 744

46064 744

D4021-5 Manufactured No
Blanking Plate 150 Each 12.0000 2 2

Location Loc Qty Loc Code
ST112 12

64243 12

MS20600-AD4W3 Purchased No
Cherry Rivets 150 Each 1,383.000 2 2

Location Loc Qty Loc Code
ST321 1383

107939 754

111636 629

EP511/01/24
EP511/01/24
EP511/01/24
EP511/01/24
EP511/01/24

Wednesday, January 05, 2011 1:01:55 PM

Shop Packet Print

Page 5

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Wednesday, January 05, 2011 1:01:55 PM

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Work Order ID: 64987

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

1,746.000

6

6



Nut

Handwritten signature
1/5/11

Location

Loc Qty

Loc Code

ST300

1746

114784

9

115835

833

116373

4

116391

900

Handwritten signature
6

NAS1149F0332P

Purchased

No

150

Each

319.0000

12

12



WASHER

Handwritten signature
1/5/11

Location

Loc Qty

Loc Code

ST275

319

18057

319

Handwritten signature
12

Wednesday, January 05, 2011 1:01:55 PM

Shop Packet Print

Page 6

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

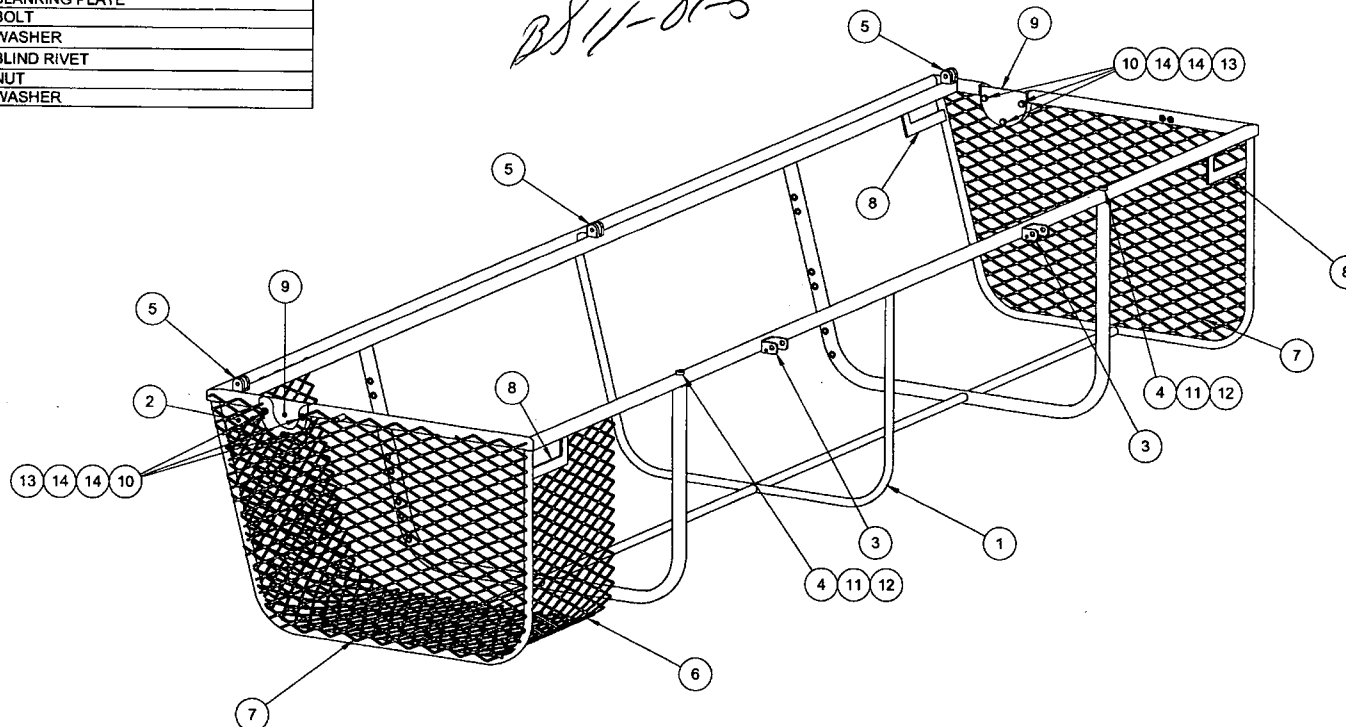
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44987
2811-01-5

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22
JPH

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3913** REV. A
SHEET 1 OF 6
TITLE **LONG BASKET BASE ASSY (350) NTS** SCALE

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ULO 64987

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D7-2

D4020-1
MESH

D8-2

D A7-3

30.00

34.50

2 PL

D2581
MOUNTING BRACKET
2 PL

D2931 BUMPER
AN960JD8 WASHER
MS20600AD4W3 RIVET
2 PL [8]

D3913-101
TUBULAR ASSY

0.75

A

45.94

45.94

D4016-1
HINGE HALF, BASE
3 PL

3 PL

D4021-1
HANDLE PLATE

D4021-1
HANDLE PLATE
2 PL

C7-3 A

C3-3 B

D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-27

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

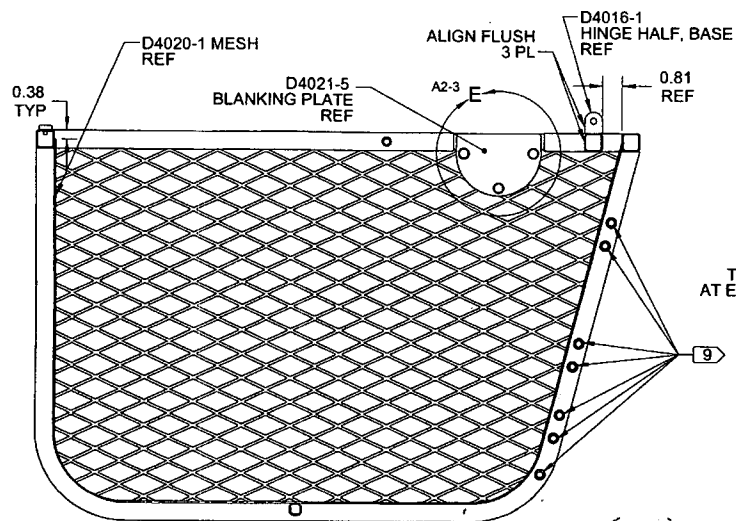
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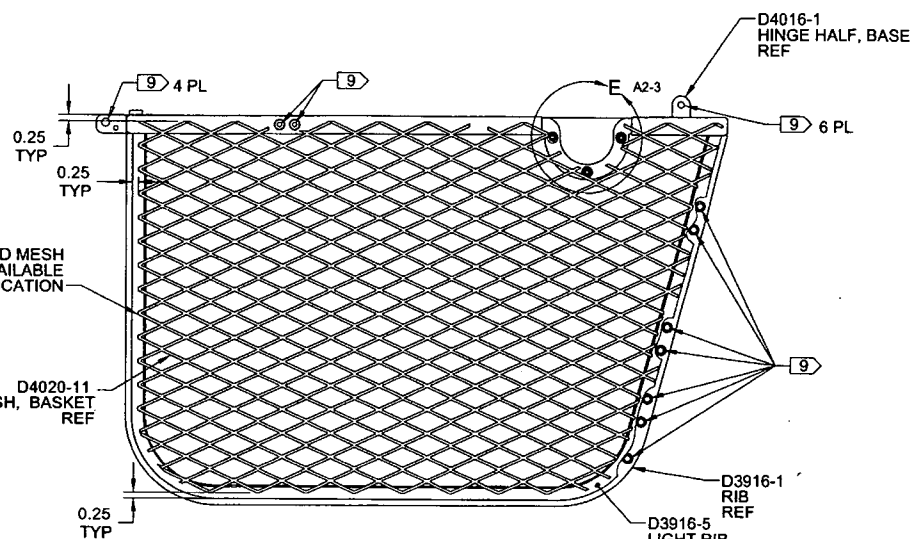
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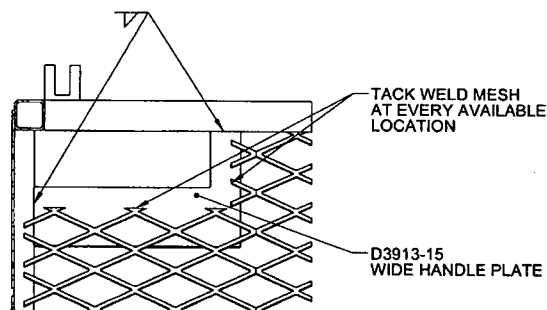
SECTION A-A A5-2

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

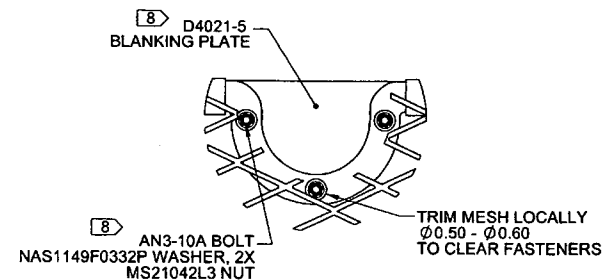
D4020-11
END MESH, BASKET
REF



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL D2-3
D6-3

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

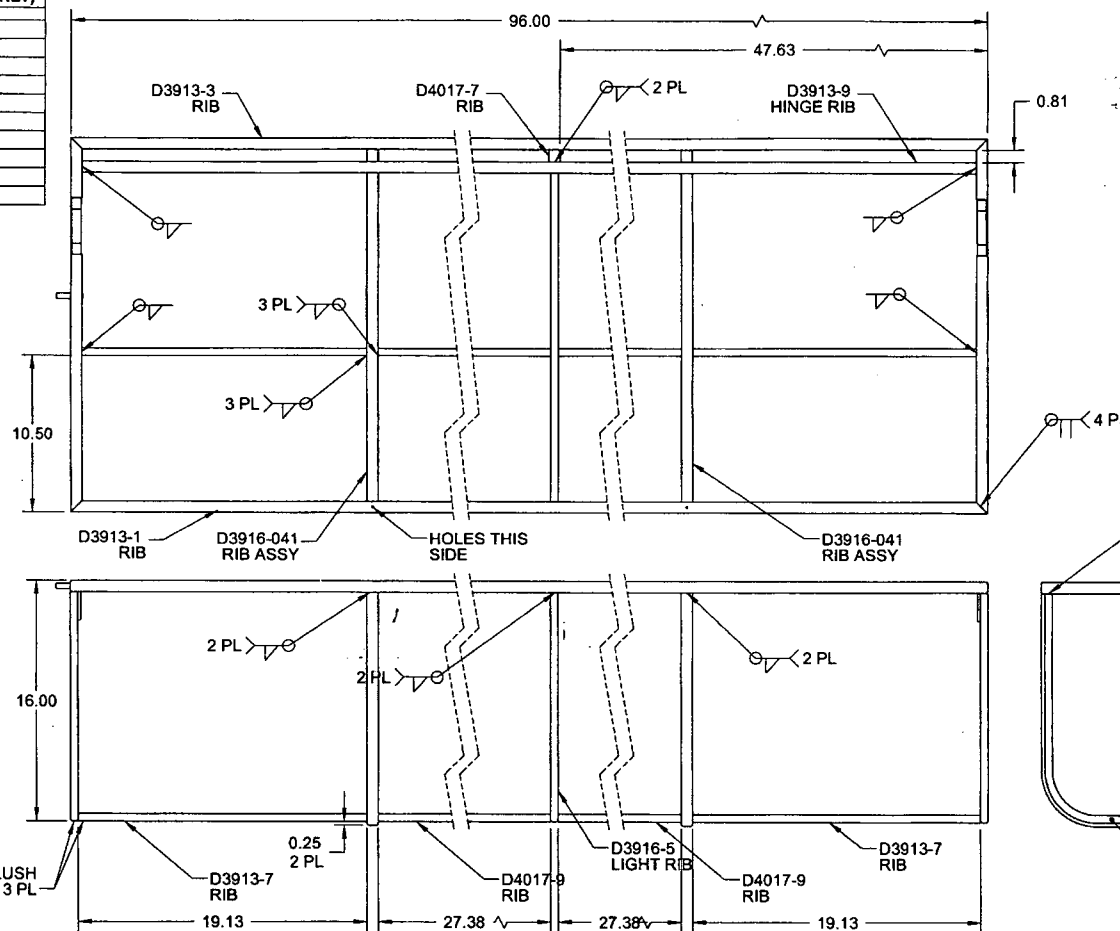
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

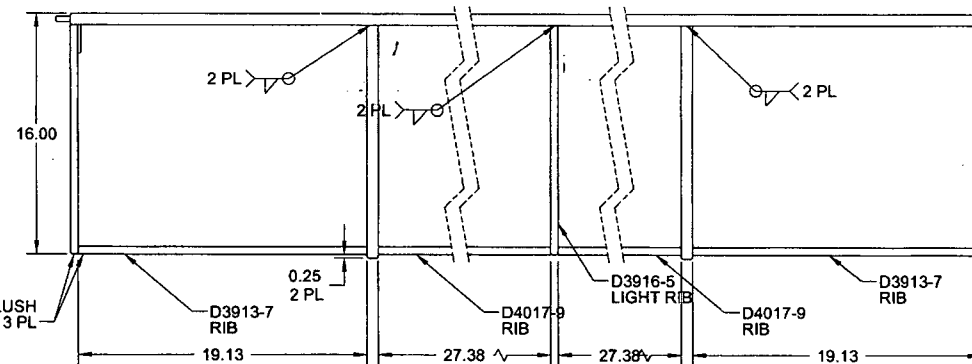
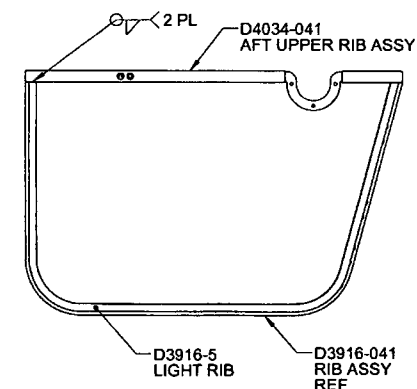
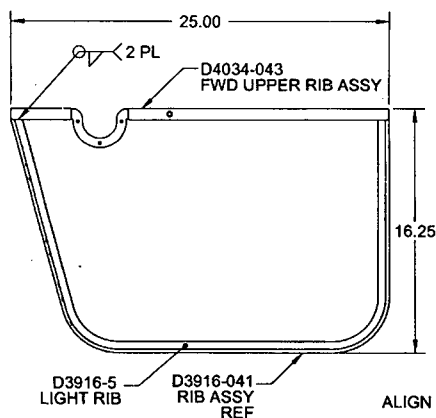
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	-101		
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



U/L 64987



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JRH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3913	SHEET 4 OF 8
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	LONG BASKET BASE ASSY (350)	NTS
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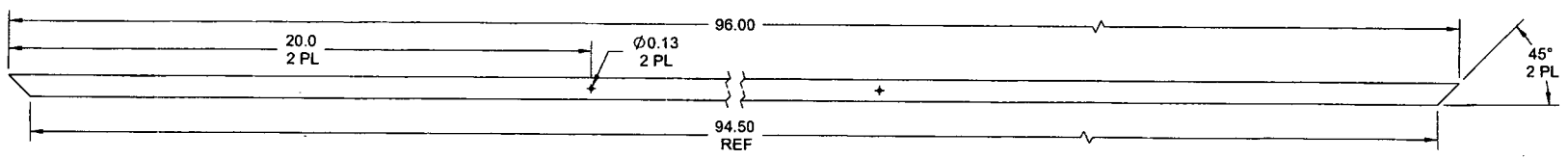
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

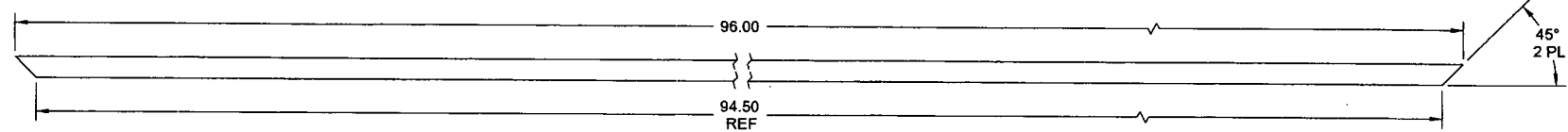
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

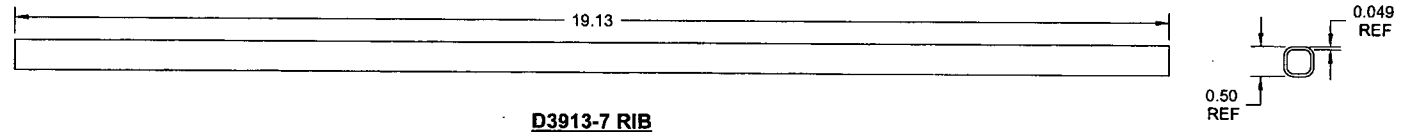


D3913-1 RIB

W/O 64987



D3913-3 RIB



D3913-7 RIB







D3913-9 HINGE RIB

NOTES:

- 1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 5 OF 6
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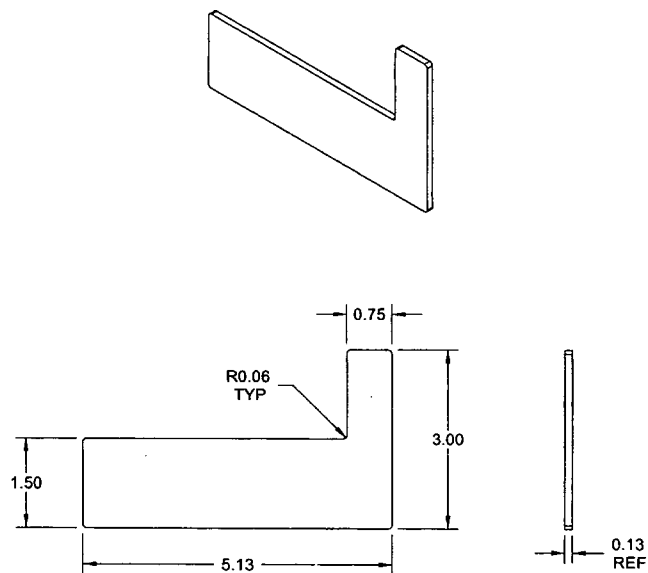
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			





NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH.
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
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JFH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries